

Date: Thursday, 12/20/2007 3:16:20 PM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : INNER AFT SADDLE
Job Number : 36462	
Estimate Number : 11082	
P.O. Number :	Part Number : D5957
This Issue : 12/20/2007 S.O. No. :	Drawing Number : D5957 REVB
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 35036	Material :
Written By :	Due Date : 1/12/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JA 07.12.21</u>	
Comment : Est Rev:E Re-Format 05-11-29 JLM	
Est Rev:F ecn826 06.12.06 ec	

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D6101007

7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

D6101-007(7075-T7351)

Size 2.50" x 7.50" X 8.25" (Grain along 7.50")

Batch: B34875

8F 08/01/28

2.0

HAAS3

HAAS CNC VERTICAL MACHINING #3



Comment: HAAS CNC VERTICAL MACHINING #3

1-Machine as per folio D5957, Ensure Batch Number is entered

2-Machine Keyway

3-Deburr &amp; Tumble

361 8F 08/01/28 (10)

3.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

36

05.01.29

10

4.0

QC8

SECOND CHECK



Comment: SECOND CHECK

361 08/01/30

(10)

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JD 8-1-30 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 28/02/04

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/20/2007 3:16:20 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: INNER AFT SADDLE

Job Number: 36462

Part Number: D5957

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M106379



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

JP 08-01-31 (X10)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

JP 08-01-31 (10)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 421

JP 08/02/01 (X10)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

2008/02/04

Job Completion



JP 2008/2/04 (10)

h

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	36462
<b>Description:</b> Inner Aft Saddle		<b>Part Number:</b>	D5957
<b>Inspection Dwg:</b> D5957	<b>Rev:</b> B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.441	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.002	7.002	7.002	7.002		
E	5.745	5.755		5.750	5.750	5.750	5.750		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.318	.318	.318	.318		
H	1.522	1.532		1.530	1.530	1.530	1.530		
I	3.048	3.058		3.050	3.050	3.050	3.050		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.313	0.318		.318	.318	.318	.318		
L	0.495	0.505		.503	.503	.503	.503		
M	0.490	0.510		.507	.507	.507	.507		
N	1.865	1.885		1.875	1.875	1.875	1.875		
O	7.990	8.010		8.000	8.000	8.000	8.000		
P	2.240	2.260		2.250	2.250	2.250	2.250		
Q	0.307	0.312		.310	.310	.310	.310		
R	0.760	0.765		.760	.764	.764	.764		
S	0.490	0.510		.505	.502	.502	.502		
T	1.625	1.645		1.635	1.632	1.632	1.632		
U	2.000	2.020		2.000	2.000	2.000	2.000		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	S.F. / B.E.
Date:	05/01/28

Audited by:	ML
Date:	08/01/30

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.11.20	Added dimension V	KJ/JLM	
D	06.12.06	Dimensions L,N,P revised	KJ/EC	
E	07.06.15	Dimension G revised	KJ/JLM	

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	36462
<b>Description:</b> Inner Aft Saddle		<b>Part Number:</b>	D5957
<b>Inspection Dwg:</b> D5957	<b>Rev:</b> B	Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing and record below:

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C	5.245	5.255		5.250	5.250	5.250	5.250		
D	6.995	7.005		7.000	7.000	7.000	7.000		
E	5.745	5.755		5.750	5.750	5.750	5.750		
F	4.745	4.755		4.750	4.750	4.750	4.750		
G	0.315	0.322		.318	.318	.318	.318		
H	1.522	1.532		1.527	1.527	1.527	1.527		
I	3.048	3.058		3.053	3.053	3.053	3.053		
J	4.575	4.585		4.580	4.580	4.580	4.580		
K	0.313	0.318		.318	.318	.318	.318		
L	0.495	0.505		.500	.500	.500	.500		
M	0.490	0.510		.506	.506	.506	.506		
N	1.865	1.885		1.875	1.875	1.875	1.875		
O	7.990	8.010		8.002	8.002	8.002	8.002		
P	2.240	2.260		2.255	2.255	2.255	2.255		
Q	0.307	0.312		.311	.311	.311	.311		
R	0.760	0.765		.764	.764	.764	.764		
S	0.490	0.510		.503	.503	.503	.503		
T	1.625	1.645		1.632	1.632	1.632	1.632		
U	2.000	2.020		2.000	2.000	2.000	2.000		
V	0.023	0.043		.033	.033	.033	.033		
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:	RF
Date:	05.01.29

Audited by:	ML
Date:	08/01/30

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<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	36462
<b>Description:</b> Inner Aft Saddle		<b>Part Number:</b>	D5957
<b>Inspection Dwg:</b> D5957	<b>Rev:</b> B	<b>Page 1 of 1</b>	

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	9 1	10 2	3	4	By	Date
A	0.438	0.443		.440	.440				
B	1.745	1.755		1.750	1.750				
C	5.245	5.255		5.250	5.250				
D	6.995	7.005		7.000	7.000				
E	5.745	5.755		5.750	5.750				
F	4.745	4.755		4.750	4.750				
G	0.315	0.322		.318	.318				
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M	0.490	0.510		.506	.506				
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T	1.625	1.645		1.635	1.635				
U	2.000	2.020		2.000	2.000				
V	0.023	0.043		.033	.033				
W									
X									
Y									
Z									
AA									
AB									
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AD									
AE									
AF									
AG									
AH									
Accept/Reject									

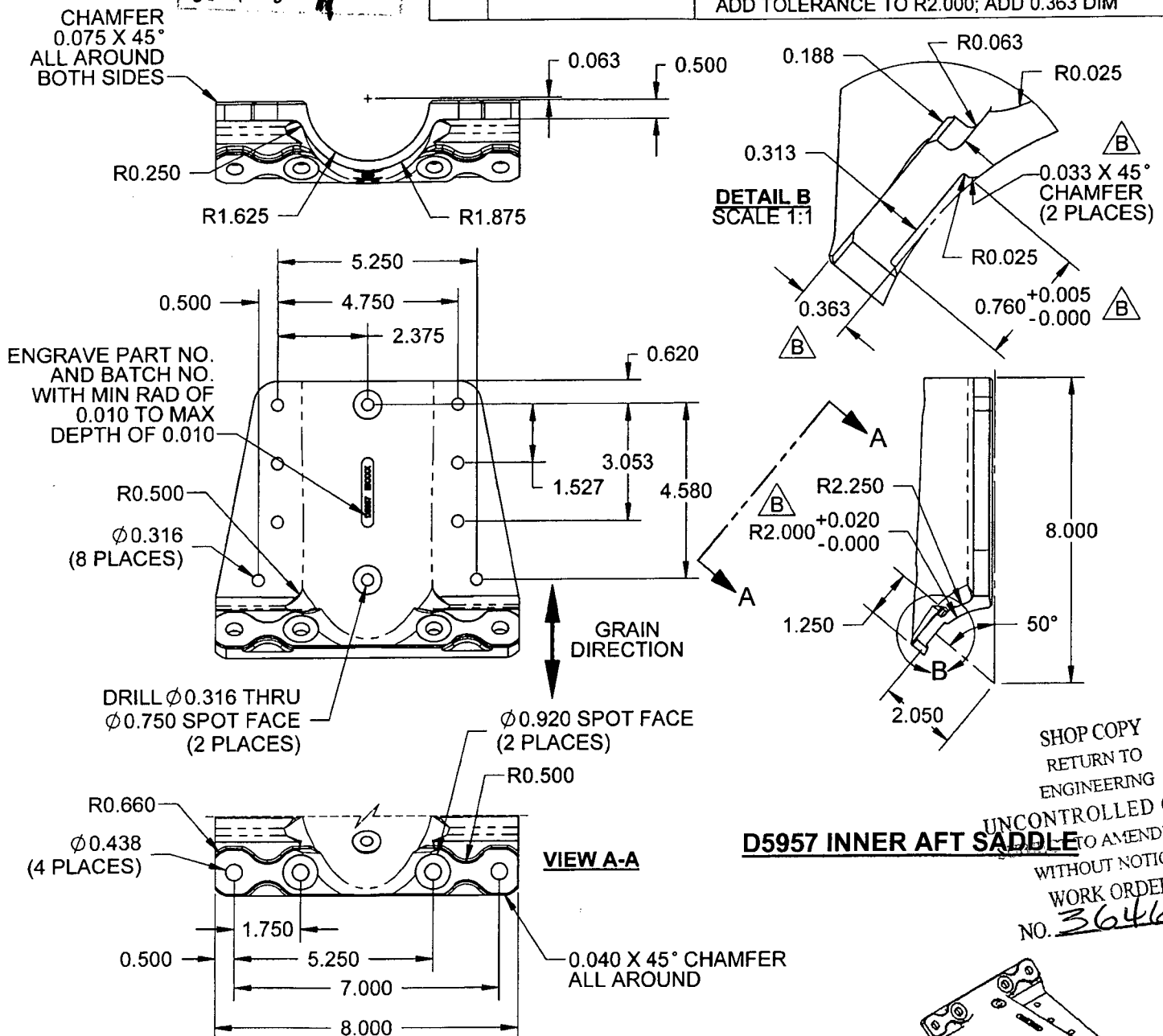
Measured by:	RF
Date:	02.01.29

Audited by:	RF
Date:	08/01/30

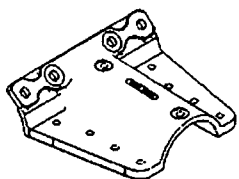
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**DART**

DESIGN <b>BW</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>LE</b>	APPROVED <b>[Signature]</b>	DRAWING NO. <b>D5957</b>	REV. B SHEET 1 OF 1
DATE <b>06.11.07</b>	TITLE <b>INNER AFT SADDLE</b>		SCALE 1:4
REV <b>A</b>	DATE <b>97.05.06</b>	DESCRIPTION <b>NEW ISSUE</b>	
<b>B</b>	<b>06.11.07</b>	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; Ø0.316 WAS Ø0.313; ADD TOLERANCE TO R2.000; ADD 0.363 DIM	

**NOTES:**

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12  
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

**ISOMETRIC VIEW**  
SCALE 1:8

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